

Date: Thursday, 6/21/2007 1:51:48 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUPPED WASHER
Job Number : 33096	
Estimate Number : 12885	
P.O. Number : <i>N/A</i>	Part Number : D36283
This Issue : 6/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : UNDER REVIEW D3628 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : <i>N/A</i>
Previous Run : 33093	Material : <i>N/A</i>
Written By : _____	Due Date : 6/28/2007 Qty: 50 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-05-28 JLM	

## POSITIVE RECALL

Additional Product

EFFECTIVE *07/06/21* AUTH *W*

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 cut per drwg D3628 Rev.A

*B*  
*ml 07 06 25*

(50)

2.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.0300 sf(s)/Unit Total: 1.5000 sf(s)  
 304/316 .050 Sheet  
*b ml 07 06 25*

(50)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*B*  
*ml 07 06 25*

(50)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



**ENGINEERING  
 APPROVAL**

Comment: SECOND CHECK

*W 07/06/26*

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



*ml 07/06/27 x51*  
*SAD 07/06/26*

(50)

Comment: SMALL & MEDIUM FAB RESOURCE 1  
 FORM PER DRGW D3628 REV.A

*SAD 07/06/27*

(50)

*W 07/06/26*

(50)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 07/06/28*

(counter)

(x51)

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/26/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 1:51:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 33096

Part Number: D36283

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



*m 104846*



*(51)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*BA/M/ 07-06-28*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/4/29 (51)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock

Location: *57120*

*LABEL CODE re/paint*

*07/4/29 (51)*

POSITIVE  
RECALL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(51)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/29*

Job Completion



*07-06-29*

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED *h* DATE *07-06-29*

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

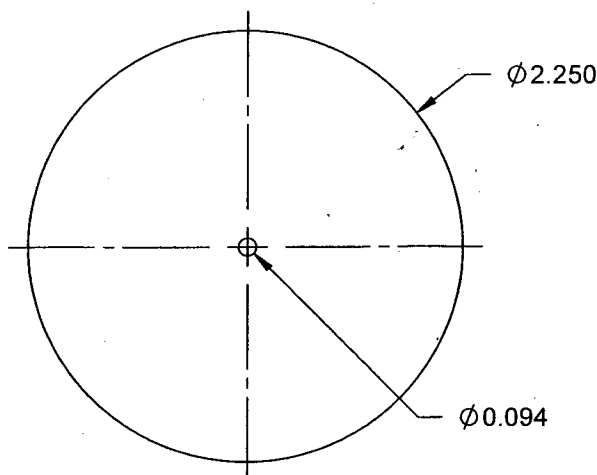
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**PRELIMINARY ISSUE**

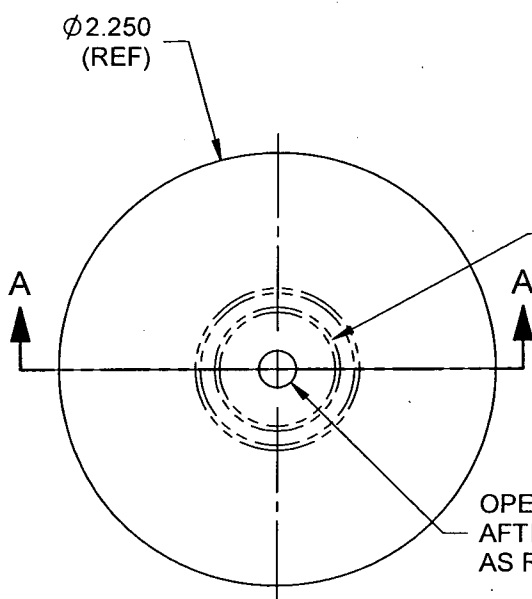
DESIGN CB	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED	DRAWING NO. D3628	REV. A SHEET 1 OF 1
DATE 07.06.08		TITLE CUPPED WASHER	SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33096



**D3628-1F FLAT PATTERN**

PUNCH  $\phi 0.64 \times 0.16$  DEEP

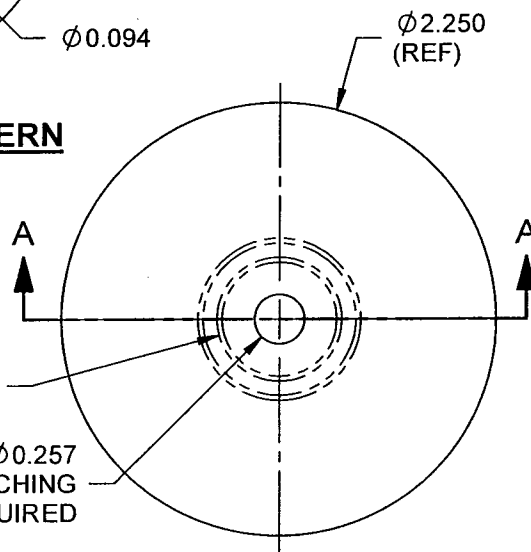


**D3628-1 CUPPED WASHER**  
(MAKE FROM D3628-1F)

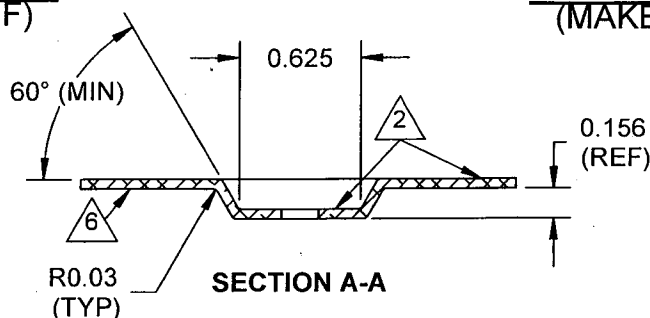
OPEN TO  $\phi 0.191$   
AFTER PUNCHING  
AS REQUIRED



OPEN TO  $\phi 0.257$   
AFTER PUNCHING  
AS REQUIRED



**D3628-3 CUPPED WASHER**  
(MAKE FROM D3628-1F)



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3 ONLY TOP SURFACE AS INDICATED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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